



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4653-11
Job Sheet 185044



Part No: D4653-11

Job Qty: 20 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 9 IPP REV:A 12/06/12 NEW ISSUE JFS VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-3		mmmk 18/11/18
100	Bandsaw	20 pcs	11/9/18	11/9/18	0.00	0.00	Bandsaw1		"
110	CNC Vertical Machining	20 pcs	11/9/18	11/9/18	0.09	10.87	HAAS1-5		"
120	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-3		"
130	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-3		"
140	Packaging	20 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-2	Stacy	NOV 26 2018
150	QC21-SA	20 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 100 - CUT BLANK AT 3.025"

Descriptions: 110 - MACHINE AS PER DWG & FOLIO FB119

DAS

21

9-59

NOV 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINB1.000X4.000	Delrin Bar	5.0400 ft (.252 ea)	90-Start up Operation	5036560241 5109932 = 1.75

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINB1.000X4.000	5	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	1.080Inches ± 0.030	1.110 1.050	Radius	
2	Clamp	1.200Inches ± 0.030	1.230 1.170	Radius	
3	Clamp	1.450Inches ± 0.030	1.480 1.420	Radius	
4	Clamp	0.280Inches ± 0.030	0.310 0.250		
5	Clamp	0.030Inches ± 0.030	0.060 0.000		
6	Clamp	45.000Degrees ± 0.500	45.500 44.500		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

7	Clamp	0.030Inches ± 0.030	0.060 0.000	Radius
8	Clamp	0.020Inches ± 0.030	0.050 (0.010)	
9	Clamp	45.000Degrees ± 0.500	45.500 44.500	
10	Clamp	0.032Inches ± 0.010	0.042 0.022	Radius
11	Clamp	0.015Inches ± 0.010	0.025 0.005	
12	Clamp	45.000Degrees ± 0.500	45.500 44.500	
13	Clamp	0.850Inches ± 0.030	0.880 0.820	
14	Clamp	0.130Inches ± 0.030	0.160 0.100	
15	Clamp	0.060Inches ± 0.030	0.090 0.030	
16	Clamp	0.120Inches ± 0.030	0.150 0.090	
17	Clamp	2.250Inches ± 0.030	2.280 2.220	Diameter
18	Clamp	0.130Inches ± 0.030	0.160 0.100	
19	Clamp	0.100Inches ± 0.030	0.130 0.070	
20	Clamp	0.300Inches ± 0.030	0.330 0.270	
21	Clamp	0.150Inches ± 0.030	0.180 0.120	
22	Clamp	2.430Inches ± 0.030	2.460 2.400	Diameter

Plex 10/22/18 11:05 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

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DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaero.com DART AEROSPACE Container No: S126089 Part: D4653 - 11 Job No: 185044 Serial No/Batch: S126089 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's <table style="width: 100%;"> <tr> <td style="width: 30%;"> Environ _____ Doc/Data _____ Equip/Tooling _____ Handling/Pre _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____ </td> <td style="width: 30%;"> Supplier _____ Training _____ Use for Testing _____ Poor Information _____ Rushing _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____ </td> <td style="width: 30%;"> Crimp/Kink/Ripple/Wave _____ Cuffs _____ Crushing _____ Heat Treat _____ Wave/Twist in Tube _____ Marks/Chatter _____ OTHER : _____ </td> <td style="width: 30%;"> Contamination _____ Countersink _____ Cut Too Short _____ Instructions Incomplete/Unclear _____ Drill Holes _____ </td> </tr> </table>						Environ _____ Doc/Data _____ Equip/Tooling _____ Handling/Pre _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____	Supplier _____ Training _____ Use for Testing _____ Poor Information _____ Rushing _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____	Crimp/Kink/Ripple/Wave _____ Cuffs _____ Crushing _____ Heat Treat _____ Wave/Twist in Tube _____ Marks/Chatter _____ OTHER : _____	Contamination _____ Countersink _____ Cut Too Short _____ Instructions Incomplete/Unclear _____ Drill Holes _____												
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